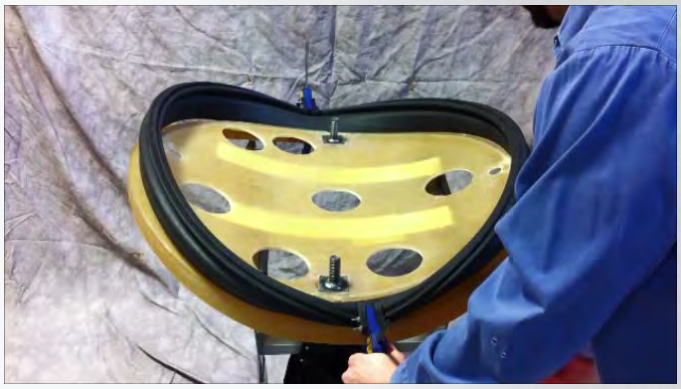
Click to see a video of these instructions

How to Use our Mandrel Installation Grips



Place two grips at 12 & 6 o'clock (the two lowest points on a curved mandrel) with the clamps underneath the outside half of the mandrel. Pull the clamp trigger until the 2 hooks fit snugly into the waterstop of the connector and starts pulling the connector down (see picture below).

Position the other two clamps at 3 and 9 o'clock. Once all four clamps are installed, make sure the nose of the connector is consistently tight against the offset.

Place the inside mandrel half on top and hand-tighten nuts and bolts. Make sure the waterstop is perpendicular to the outside wall of the mandrel. Then look through all observation holes to be sure the nose of the connector is still up against the offset. Tighten nuts with wrench. Re-check waterstop and observation holes.

Click for a video of these instructions or call us with any questions at (800) 822-2565.

PRE-POUR INSPECTION

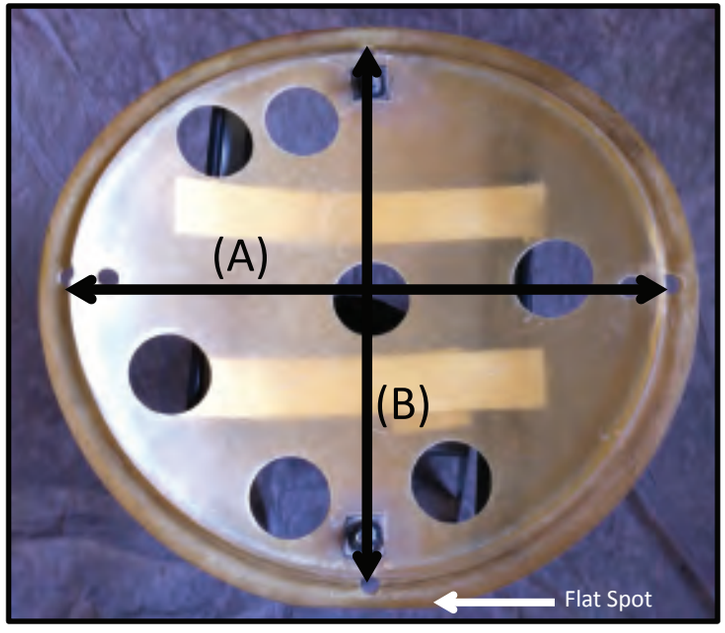


Fig.1 - Outside Mandrel Half

1. Determine your parts are correct by checking the pipe O.D. using the A-LOK Dimensional Data Sheet where you will find the correct connector and mandrel.

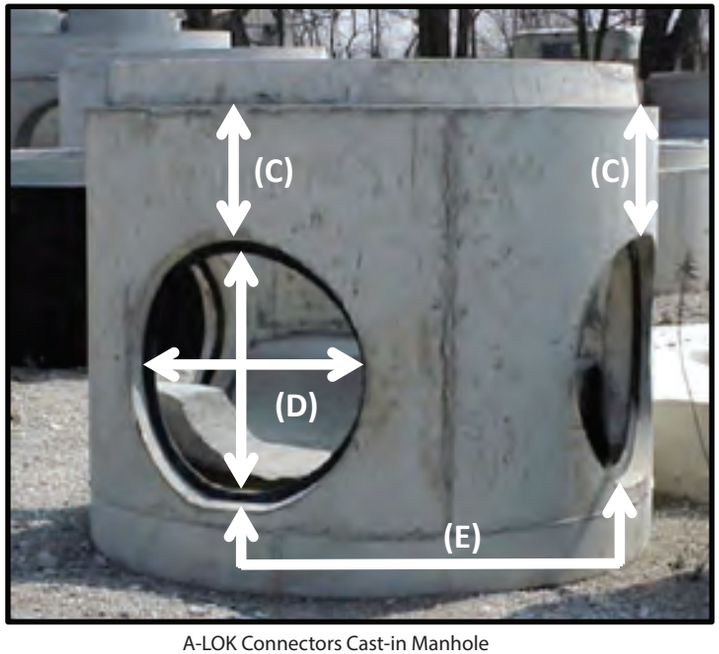
2. Measure the offset of the outside mandrel half at the 3 & 9 (A) and 6 & 12 (B) o'clock positions to check for roundness. These measurements should be within 1/4'' of each other.

3. To identify the mandrel, locate the measurement from the 6 & 12 o'clock position (B) in the mandrel I.D. column on the A-LOK Dimensional Data Sheet. The connector and mandrel should have matching part numbers.

4. After the connector has been installed on the mandrel, measure the width of the mandrel at the 12 o'clock position (Fig. 2) to determine the wall thickness.

5. Check to make sure the mandrel locations, angles and heights match the plans.

Fig. 2
A-LOK Connector
Mounted on Mandrel



A-LOK Connectors Cast-in Manhole

POST-POUR INSPECTION

1. After stripping from form, check correct placement and heights to make sure no movement or shifting has occurred by using a common reference point (C).

2. Measure the connector's inside dimension at 12 & 6 and 3 & 9 o'clock positions for concentricity (D). These measurements should be within 1/4'' of each other. Compare measurements with our Dimensional Data Sheet.

3. Check angle placement of connectors by measuring the center-to-center dimensions of the connectors (E). The angle can be determined by using the following formula:

$$\frac{\text{Structure OD} \times \pi}{360} = \frac{\text{inches}}{\text{degree}}$$

4. Visually check connector for consistent embedment all the way around and to ensure it is not damaged. Make sure the flat spot is on the bottom (B).

Manhole Quality Assurance Worksheet

Manhole Number	Pipe Penetration Degree	Invert Elevation	Type of Pipe	A-LOK Connector Number	A-LOK Ring ID Measurement	A-LOK Ring OD Measurement	Actual Mandrel ID Pre-pour		Date	Actual Connector ID Post-Pour		Date	PASS/FAIL and Initials
							12-6	3-9		12-6	3-9		

The back of this worksheet has detailed information and instructions depicting how to achieve the correct measurements regarding Pre-Pour and Post-Pour Quality Assurance.

Please call A-LOK with any questions at (800) 822-2565.

MANDREL MOUNTING INSTRUCTIONS FOR A•LOK CONNECTORS

WARNING:

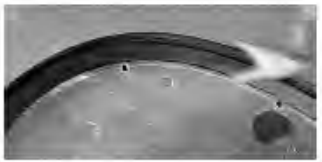
IMPROPER INSTALLATION OF CONNECTOR ON THE MANDREL COULD CAUSE THE CONNECTOR TO FAIL. MANDRELS SHOULD ONLY BE USED IN THE FORMS THEY ARE DESIGNED. ANY OTHER USE COULD CAUSE DIMENSIONAL DAMAGE TO THE MANDREL.

STEP 1. REMOVE NUTS AND SEPARATE MANDREL HALVES.

STEP 2. MEASURE OFFSET DIMENSION 3-9 AND 6-12 TO BE SURE IT MATCHES THE CONNECTOR I.D.

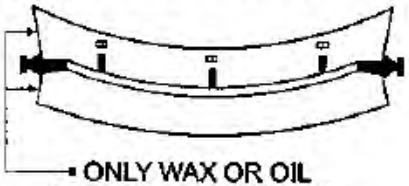
REFER TO A•LOK DIMENSIONAL DATA SHEET FOR THE CORRECT A•LOK CONNECTOR I.D.

STEP 3. PLACE CONNECTOR NOSE AGAINST THE MANDREL OFFSET ON THE OUTSIDE HALF.



STEP 4. ROLL CONNECTOR TO A HORIZONTAL POSITION.

NOTE: CONNECTOR'S NOSE MUST FIT FLUSH AGAINST MANDREL OFFSET.



STEP 5. SET INSIDE HALF OF MANDREL ON TOP AND TIGHTEN NUTS.

ONLY WAX OR OIL OUTSIDE OF MANDREL. **(NOT THE GASKET)**

STEP 6. CHECK ALL INSPECTION HOLES TO INSURE THE CONNECTOR IS TIGHT ABOUT THE OFFSET.

MOUNTING MANDRELS ON FORM

IMPORTANT: MANDRELS SIZE 600 AND ABOVE – FLAT SPOT MUST BE PLACED ON THE OUTSIDE TOWARDS THE BOTTOM OF THE STRUCTURE TO INSURE PIPE WILL BE CENTERED IN CONNECTOR DURING INSTALLATION.

Tel: 1-800-822-2565 • Fax: 215-547-5260 • Web site: www.a-lok.com • E-mail: info@a-lok.com

A•LOK® PRODUCTS, INC.